



526 Rec'd PCT/PTO 29 SEP 2000

TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		ATTORNEY'S DOCKET NUMBER 00-601
INTERNATIONAL APPLICATION NO. PCT/EP99/02266	INTERNATIONAL FILING DATE April 1, 1999	U.S. APPLICATION NO. (if known, see 37 CFR 1.53) 09/647699
TITLE OF INVENTION APPARATUS FOR REMOVING BROKEN-OUT PIECES FROM A SHEET OF MATERIAL OR THE LIKE		PRIORITY DATE CLAIMED April 2, 1998
APPLICANT(S) FOR DO/EO/US FRANZ VOSSEN		
Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:		
<ol style="list-style-type: none">1. <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371.2. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371.3. <input checked="" type="checkbox"/> This express request to begin national examination procedures (35 U.S.C. 371(b)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).4. <input checked="" type="checkbox"/> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371(c)(2))<ol style="list-style-type: none">a. <input checked="" type="checkbox"/> is transmitted herewith (required only if not transmitted by the International Bureau).b. <input type="checkbox"/> has been transmitted by the International Bureau.c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US).6. <input checked="" type="checkbox"/> A translation of the International Application into English (35 U.S.C. 371(c)(2)).7. <input type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))<ol style="list-style-type: none">a. <input type="checkbox"/> are transmitted herewith (required only if not transmitted by the International Bureau).b. <input type="checkbox"/> have been transmitted by the International Bureau.c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired.d. <input type="checkbox"/> have not been made and will not be made.8. <input type="checkbox"/> A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).9. <input checked="" type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).10. <input type="checkbox"/> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).		
Items 11. to 16. below concern document(s) or information included:		
<ol style="list-style-type: none">11. <input type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98.12. <input type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.13. <input checked="" type="checkbox"/> A FIRST preliminary amendment. <input type="checkbox"/> A SECOND or SUBSEQUENT preliminary amendment.14. <input type="checkbox"/> A substitute specification.15. <input type="checkbox"/> A change of power of attorney and/or address letter.16. <input type="checkbox"/> Other items or information:		

page 1 of 2

(January 1995)

I hereby certify that this correspondence is being deposited with the United States Postal Service as Express Mail, and is being delivered to the Commissioner of Patents and Trademarks, Washington, D.C. 20231

Express Mail Label
No. EL398544515US

September 29, 2000

Antoinette Sullo

9-29-00

Date of Signature

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant : FRANZ VOSSEN Docket No.: 00-601
Serial No.: Examiner :
Filed : Art Unit :
For : APPARATUS FOR REMOVING BROKEN-OUT
PIECES FROM A SHEET OF MATERIAL
OR THE LIKE

900 Chapel Street
Suite 1201
New Haven, CT 06510-2802

PRELIMINARY AMENDMENT

Hon. Commissioner of Patents and Trademarks
United States Patent and Trademark office
Washington, D.C. 20231

Dear Sir:

In the above-identified application for United States
patent, please amend as follows:

IN THE CLAIMS

Prior to calculating the filing fee due, cancel claims 1-38,
all the claims in the case, and substitute the following claims
therefor.

39. Apparatus for removing broken-out pieces, in particular
waste portions (12), from a sheet of material (10) which contains
blanks or the like flat portions and which rests on a female die
(14) or the like breaking-out surface in such a way that the
broken-out portion extends over an opening (16) in the breaking-
out surface and is urged away through the opening under the
pressure of at least one breaking-out tool (40, 41), wherein

associated with the breaking-out tool is a support means (20, 20_a, 20_b, 20_n) which is movable in the direction of movement of the breaking-out tool and which is rigidly connected in positively locking relationship to the breaking-out surface or female die in the edge region of the opening and which projects into the opening with a support or contact surface (24, 25, 34) which can be inclined with respect to said connection pairing and which in the rest position engages in substantially parallel relationship under the waste portion or broken-out piece disposed in the sheet of material and which is adapted to be variable in its position upon the movement of the waste portion by the breaking-out tool and in particular is adapted to be transferred into an angle of inclination relative to the sheet of material in the downward movement of the waste portion, wherein the connection pairing for the support means comprises at least one undercut receiving groove (28, 31) on the one hand and a portion (27, 29) which can be fitted thereinto and which extends in the breaking-out direction (x) on the other hand, characterized in that the cross-sections of the receiving groove (28, 31) and the portion forming a coupling rib or bar (27, 29) are of a dovetail-shaped configuration, wherein the support means (20, 20_a, 20_b, 20_n) is in longitudinal section an angle portion with at least one coupling rib (27) which is formed out of one of its limbs (22) for a receiving groove (28) of the female die (14) or with a vertical groove (31) formed in a limb (22) for a coupling rib

(29) of the female die on the one hand and with another flexible limb (24, 34) forming the support surface (25) on the other hand.

40. Apparatus for removing broken-out pieces, in particular waste portions (12), from a sheet of material (10) which contains blanks or the like flat portions and which rests on a female die (14, 14_a) or the like breaking-out surface in such a way that the broken-out portion extends over an opening (16, 16_a) in the breaking-out surface and is urged away through the opening under the pressure of at least one breaking-out tool (40, 41), wherein associated with the breaking-out tool is a support means (20_a, 62) which is movable in the direction of movement of the breaking-out tool and which is rigidly connected in positively locking relationship to the breaking-out surface or female die in the edge region of the opening and which projects into the opening with a support or contact surface (24, 25, 34) which can be inclined with respect to said connection pairing and which in the rest position engages in substantially parallel relationship under the waste portion or broken-out piece disposed in the sheet of material and which is adapted to be variable in its position upon the movement of the waste portion by the breaking-out tool and in particular is adapted to be transferred into an angle of inclination relative to the sheet of material in the downward movement of the waste portion, wherein the connection pairing is adapted to be brought together in the breaking-out direction (x), characterized in that the connection pairing comprises at least

one receiving groove (28_a, 28_b) in the female die (14) at the edge of the opening (16) thereof on the one hand and a portion (80, 92, 97), which can be fitted thereinto, of a vertical limb (22) of the support tool (20_e, 20_f, 21) on the other hand, or that the connection pairing comprises a plug-in profile portion (65) of the female die and an associated hollow profile portion (63) which is formed by a limb of an angle portion as a shaped support portion (62) whose other limb is a support lip (64), wherein the shape of the hollow profile portion corresponds to that of a cylindrical cup.

41. Apparatus as set forth in claim 40, characterized in that formed on the vertical limb (22) is at least one pin-like plug-in element (80, 92) which extends or extend at a spacing (y) relative to the vertical limb and which is respectively adapted to be inserted into an opening (84, 94) provided in the female die (14) at a spacing (y) relative to the receiving groove (28_a) and is removable in the breaking-out direction (x).

42. Apparatus as set forth in claim 41, characterized in that the plug-in element (80, 92) and the opening (84) are of rectangular cross-section and/or that the plug-in element (80) projects from a transverse web portion (82) at a spacing (y) relative to the rear surface of the vertical limb (22).

43. Apparatus as set forth in claim 41, characterized in that the plug-in element (80, 92) projects up from a transverse web portion (82) at a spacing (y) relative to the flank surface of the vertical limb (22).

44. Apparatus as set forth in claim 40, characterized in that the flank surfaces (88) of the vertical groove (28_a, 28_b) are stepped and the vertical limb (22) is supported in the rear region (90) of the vertical groove, which rear region is of narrower cross-section.

45. Apparatus as set forth in claim 40, characterized in that the vertical limb (97) is fitted with a plug-in slot (98) on to a limb (100) of an angle bracket (102), which extends in the vertical groove (28_b), while the other limb (101) of the angle bracket is connected to the female die (14).

46. Apparatus as set forth in claim 40, characterized in that shaped support portions (62) which are arranged in the opening (16_a) at the edge thereof and which are fitted on to plug-in profile members (65) are disposed in mutually opposite relationship, the support portions (62) being provided with radial support lips (64) of elastic material which are directed towards each other.

47. Apparatus as set forth in claim 39, characterized in that the flexible limb (24) forming the support surface (25) has an edge opening (32) which is delimited on both sides by cantilever portions (34), and at least one inner opening (30) at a spacing in relation to the edge opening (32).

48. Apparatus as set forth in claim 39, characterized in that arranged downstream, in the breaking-out direction (x), of the limb (24) forming the support surface (25) is at least one catch finger (38), in particular a pair of catch fingers.

49. Apparatus as set forth in claim 39, characterized in that the limb (24) forming the support surface (25) is flanked by side portions which are formed on the other limb (22) and form the catch fingers (38).

50. Apparatus as set forth in claim 48, characterized in that the catch finger (38) is enlarged in longitudinal section from its free end (36) towards the limb (22) formed thereon.

51. Apparatus as set forth in claim 39, characterized in that the support tool (20_a) has a partial frame which is substantially U-shaped in cross-section and which comprises a back portion including the coupling rib or ribs (27), with two parallel side walls (23), wherein a support plate (46, 46_a) is arranged pivotably about an axis (A) between the side walls.

52. Apparatus as set forth in claim 39, characterized in that the breaking-out tool or tools (40; 41, 42) extends or extend between surfaces (34, 34_a) of the support means (20, 20_a, 20_b, 20_n), said surfaces being movable in the breaking-out direction (x).

53. Apparatus as set forth in claim 39, characterized in that the portion (24; 46, 46_a; 64) including the support surface (25) is provided at its free edge (35) with at least one edge opening (32), wherein possibly the edge opening or openings is or are disposed in opposite relationship to the free end or ends of the breaking-out tool (40, 41).

54. Apparatus as set forth in claim 39, characterized in that disposed opposite the support surface (25) as a breaking-out tool is a pressure pin (40) with a rounded free end which is in the form of a rough surface.

55. Apparatus as set forth in claim 39, characterized in that associated with the support surface (25) as a breaking-out tool is a fork member (41, 41_a, 41_b) with one or more finger-like fork prongs (42, 42_a, 42_b) of preferably flat cross-section, wherein preferably the free end of the pressure pin (40) or the fork prong (42, 42_a, 42_b) is in the form of a rough surface.

56. Apparatus as set forth in claim 55, characterized in that the free end of the fork prongs (42, 42_a, 42_b) is formed by a part-circular curve (43_a in Figures 18, 23) formed therein or a tip (Figures 30, 31) formed out thereon.

57. Apparatus as set forth in claim 54, characterized in that the rough surface is formed by a coating (44), in particular a coating with oxides, carbides, corundum or the like.

58. Apparatus as set forth in claim 54, characterized in that the coating (44) is applied by means of thermal spraying.

59. Apparatus as set forth in claim 54, characterized in that the rough surface is formed by a coating of plastic material or rubber.

60. Apparatus as set forth in claim 54, characterized in that the rough surface is formed by irregularities provided in the surface of the pressure pin (40) or the fork prongs (42, 42_a, 42_b), wherein the surface of the pressure pin or the fork prongs (42) is roughened mechanically, chemically or electrically.

61. Apparatus as set forth in claim 55, characterized in that the axial height (h) of the rough surface (44) corresponds at most to the diameter (d) of the pressure pin (40) or the width of the fork prong (42).

62. Apparatus as set forth in claim 54, characterized in that projecting teeth (61, 61_a), hooks (61_b) or at least one shoulder (61_c) in inclined relationship are formed out at the pressure pin (40) or fork prongs (42, 42_a, 42_b) near the end at a spacing in relation thereto.

63. Apparatus as set forth in claim 55, characterized in that the fork member (41) projects from a plate-shaped male die (56), wherein possibly the portion of the fork member (41), which is connected to the male die (56), has clamping noses (60) and/or abutments (54).

64. Apparatus as set forth in claim 39, characterized by a clip-like tool (68 through 74) which is fixed to the opening (16, 16_a) and which respectively includes a frame portion (76) from which resilient support tongues (34_b) project inwardly or on which at least one inwardly disposed support plate (46_b) is arranged movably about a pivot axis (A).

65. Apparatus as set forth in claim 64, characterized by a frame portion (76) which is at least partially curved in plan view or by a substantially rectangular frame portion (76).

R E M A R K S

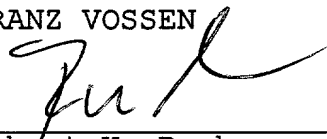
The instant Preliminary Amendment is submitted so as to cancel the originally filed claims and insert new claims 39-65 which are the claims as amended during the prosecution of the international application.

An early action on the merits is requested.

Respectfully submitted,

FRANZ VOSSEN

By


Robert H. Bachman
Attorney for Applicant

Area Code: 203
Telephone: 777-6628
Telefax : 865-0297

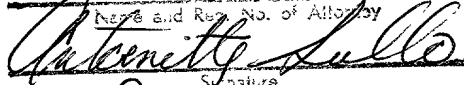
Date: September 29, 2000

I hereby certify that this correspondence is being
Deposited with the United States Postal Service as
Express Mail in an envelope addressed to Commissioner
of Patents and Trademarks, Washington, D.C. 20231

on September 29, 2000
(Date of Deposit)

Antoinette Sullo

Name and Reg. No. of Attorney



Signature

9-29-00

Date of Signature

Express Mail Label
No. EL398544515US

09/647699

528 Rec'd PCT/PTO 29 SEP 2000

IN THE UNITED STATES PATENT AND TRADE MARK OFFICE

VERIFICATION OF TRANSLATION

I, Michael Wallace Richard Turner, Bachelor of Arts, Chartered Patent Attorney, European Patent Attorney, of 1 Horsefair Mews, Romsey, Hampshire SO51 8JG, England, do hereby declare that I am conversant with the English and German languages and that I am a competent translator thereof;

I verify that the attached English translation is a true and correct translation made by me of the attached specification in the German language of International Application PCT/EP99/02266;

I further declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment or both under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Date: September 22, 2000MWR Turner

M W R Turner

Express Mail
Label No.
EL398544515US

I hereby certify that this correspondence is being
deposited with the United States Patent Service as
Express Mail in order to be received by the Commissioner
of Patents and Trademarks, Washington, D.C. 20231

on September 29, 2000Antoinette Sullo

Name and Reg. No. of Translator

Antoinette Sullo

Signature

9-29-00

Date of Signature

PCT

WORLD INDUSTRIAL PROPERTY ORGANISATION
International Bureau

INTERNATIONAL APPLICATION PUBLISHED IN PURSUANCE OF THE PATENT CO-OPERATION TREATY (PCT)

(51)	International Patent Classification ⁶ : B26D 7/18	(11)	International Publication No. WO 99/51405
		(43)	International publication date. 14. October 1999 (14.10.99)
(21)	International application No: PCT/EP99/02266	(81)	Designated States: CA, CN, CZ, JP,TR,US European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE)
(22)	International filing date 1st April 1999 (01.04.99)		
(30)	Priority data: 198 14 736.8 2nd April 1998 (02.04.98) DE 198 20 557.0 8th May 1998 (08.05.98) DE. 198 37 316 3 18th August 1998 (18.08.98) DE 298 15 042.5 21st August 1998 (21.08.98) DE	Published With international Search Report Prior to expiry of the period allowed for amendment in the claims Publication is repeated if amendments are received	
(71)(72)	Applicant and Inventor VOSEN, Franz (-/DE) Steisslinger Strasse 46, D-78333 Stockach (DE)		
(74)	Attorney. HIEBSCH, Gerhard F et al: Hiebsch Peege Behrmann, Heinrich-Weber-Platz 1, D-78224 Singen (DE)		
(54)	Title: APPARATUS FOR REMOVING BROKEN-OUT PIECES FROM A SHEET OF MATERIAL OR THE LIKE		
(57)	Abstract		

In an apparatus for removing broken-out pieces (12), in particular waste portions, from a sheet of material containing blanks or the like flat portions, associated with a breaking-out tool (40, 42) is a support device (20) which is movable in the direction of movement of the tool and which projects into an opening (16) and which in the rest position engages substantially parallel under the broken-out piece (12) or waste portion in the sheet of material (10) and which is adapted to be variable in its position upon movement of the waste portion by the breaking-out tool (40, 42) - and in particular can be moved upon downward movement of the waste portion into an angle of inclination with respect to the sheet of material.

WO 99/51405

PCT/EP99/02266

Apparatus for removing broken-out pieces from a sheet of
material or the like

5

The invention concerns an apparatus for removing broken-out pieces, in particular waste portions, from a sheet of material containing blanks or the like flat portions, as set forth in the classifying portion of the independent claim.

10

EP 0 446 702 B1 to the present applicant discloses that automatic stamping machines for the production of blanks from sheets of card in the folding box industry have been provided for more than 30 years with breaking-out devices which are preferably arranged in a setting-up table outside the stamping machine. Such a breaking-out station is of particular importance in terms of manufacture as in the event of incorrect use it involves the highest proportion of the total setting-up time and a poorly set breaking-out station results in continual disturbances in the production procedure.

15

In the breaking-out station the stamped cardboard sheet, after reaching a predetermined detent position, on the breaking-out surface which is usually provided by a breaking-out board or a female die, is freed of the waste by means of breaking-out pins or cutting edges which press from above.

20

Development in the breaking-out procedures involved firstly entailed the top tool pin which presses downwardly from above and which passes the waste portion through the opening in the breaking-out board. There was then added an additional bottom tool with bottom pins, which are aligned with the top tool pins and which clampingly hold the waste portion. As a breaking-out tool can reliably break out a waste portion only when there is a certain force-locking engagement between the tool and the waste portion, the above-mentioned bottom pins have proven to be an

25

30

advantageous resistance at the moment when the breaking-out tool or breaking-out member comes to bear against the waste portion.

If there is a wish to avoid using a clamping tool, the breaking-out opening in the breaking-out surface must be smaller at various locations,
5 than the waste portion which is associated therewith, so that the waste portion rests with a relatively high friction, in small surface areas, on the breaking-out surface or female die. When the breaking-out pin comes into contact with the waste portion, the above-mentioned resistance occurs by virtue of the friction which is then produced. When the breaking-out pin
10 and the waste portion pass through the opening, friction occurs at the relatively close walls of the hole, whereby a certain force-locking action is achieved.

DE-A-25 35 452 discloses the so-called DYN-pin, namely a breaking-out pin having a tip or point whose substantially conical side
15 walls are of contours which are concave in cross-section, with a smooth surface. In the breaking-out procedure, that tip bears against the waste portion which, by virtue of being supported on the edges of the opening, opposes the tip with such a level of resistance that the tip can penetrate slightly into the material of the waste portion. That prevents unwanted
20 lateral deflection movement of the waste portion. As it passes through the opening, the waste portion bends, and the stressing force between it and the wall of the opening is intended to afford the DYN-pin sufficient friction for the desired force-locking engagement with the waste portion; that could then possibly make a bottom tool in itself unnecessary, when using
25 the DYN-pin.

As a simplification for breaking-out tools, above-mentioned EP 0 446 702 B1 proposes a support means which is a surface which is movable and/or resilient within the opening - at least in part in an inclined position - at a spacing relative to the breaking-out surface and which, in its rest
30 position, engages substantially parallel beneath the waste portion in the sheet of material and which, upon movement - that is to say primarily

upon downward movement - of the waste portion, is transferred, by the breaking-out member, into an angle of inclination with respect to the sheet of material. The resilient surface can be in the form of a tongue-like spring which is fixed at one end to the breaking-out surface - substantially aligned therewith in the rest position - while the free end of the tongue-like spring is arranged in the opening. Also described are angle portions having one limb aligned with the breaking-out surface while the other limb thereof is pivotably mounted beneath the breaking-out surface and is subjected to a spring loading. The resilient surface can also be afforded by rubber profile members or by bristles.

Finally, DE-C-41 24 089 provides a cuboidal breaking-out tool of rectangular cross-section, from the pressing end of which two pressing tips or points project, in line with the two narrow sides thereof.

In consideration of that state of the art relating to the breaking-out procedure, the inventor set himself the aim of substantially improving the removal of waste portions from sheets of material and simplifying the tools required for that purpose. In particular the invention seeks to provide that those tools can be used for the treatment of very small waste pieces.

That object is attained by the teaching of the independent claim; the appendant claims set forth advantageous developments. In addition the scope of the invention embraces all combinations of at least two of the features disclosed in the description, the drawings and/or the claims.

In accordance with the invention, the support means is formed by a support tool which is rigidly connected in positively locking relationship to the breaking-out surface or female die in the edge region of the opening, and is provided with a contact or support surface which can be inclined with respect to that connection pairing.

In a preferred embodiment this connection pairing comprises a vertical receiving groove - extending in the breaking-out direction - in the female die at the edge of the opening thereof on the one hand and a

coupling bar or rib which can be fitted therewith, on the other hand. In a further preferred embodiment the support tool has an undercut groove for receiving a corresponding coupling bar of the female die.

5 The respective cross-sections of the coupling bar and the receiving groove should advantageously be of a dovetail-shaped configuration and thus define an operative position which is easy to bring about. It is perhaps possible to provide a plurality of such connecting pairings.

10 In accordance with a further feature of the invention the support tool is an angle portion with at least one coupling rib of dovetail-shaped cross-section which is formed out of the one limb - being vertical in the position of installation -, and another flexible limb which forms the support surface - being horizontal in the position of installation. In that respect, it has proven to be desirable for the angle portion generally to be formed from a material of limited flexibility, which ensures a long service life.

15 In a preferred embodiment the connection pairing comprises at least one vertical receiving groove - extending in the breaking-out direction - in the female die at the edge of the opening thereof on the one hand, and a portion - which can be fitted therewith - of a vertical limb of the support tool on the other hand. The respective cross-sections of the
20 coupling bar and the opening are advantageously to be of a rectangular configuration and thus define an operative position which is easy to bring about. A plurality of such connection pairings can possibly be provided.

It has proven to be desirable if the flexible limb forming the support surface has an edge opening which is delimited at both sides by cantilever
25 portions, and, at a spacing relative to the edge opening, at least one inner opening. That configuration affords a particularly desirable support surface which is stable in respect of shape and nonetheless flexible.

It is also in accordance with the invention that formed on the vertical limb is at least one pin-like plug-in element which extends or
30 extend at a spacing relative to the vertical limb and which is respectively adapted to be inserted into an opening provided in the female die at a

spacing relative to the receiving groove. Like also the opening which receives the plug-in element, the plug-in element is to be of a rectangular cross-section, while the plug-in element projects either at a spacing relative to the back surface of the vertical limb or at a spacing relative to the flank surface of the vertical limb, from a respective transverse web portion. In the structure involving association with the flank surfaces, a pair of plug-in elements is preferred.

In a particular embodiment the flank surfaces of the vertical groove are stepped, wherein the vertical limb is supported in the back region, which is narrower in cross-section, of that stepped vertical groove, and therefore the horizontal limb projects beyond the wider front region of the vertical groove.

In another embodiment the vertical limb is to be connected with a coupling pairing to a limb, which extends in the vertical groove, of an angle bracket whose other limb is connected to the female die, preferably by means of force-locking engagement. It is however also possible to provide a pocket at the underside of the female die, for the limb of the angle bracket, whereby that limb projects in positively locking engagement into same.

So that the broken-out piece is possibly held after the releasing procedure, at least one catch finger can be arranged downstream, in the breaking-out direction, of the limb forming the support surface; a pair of catch fingers which are in flanking relationship on both sides is however preferred. The catch fingers increase in width from their free end towards the limb formed thereon, in terms of longitudinal section, for the purposes of increasing the degree of flexibility thereof. In another embodiment the horizontal limb is flanked by side portions which are formed on the other limb, and therefore extend vertically.

Another embodiment provides a support tool with a partial frame which is approximately U-shaped in cross-section and which comprises a back portion having the coupling rib and having two parallel side walls; a

support plate for the broken-out portion is arranged between said side walls, pivotably about an axis which is generally horizontal in the position of use.

5 The feature whereby the breaking-out tools extend between surfaces of the support means, said surfaces being movable in the breaking-out direction, results in a higher level of operational reliability as the arrangement affords a kind of tongs or pincer engagement; that cannot be achieved in the state of the art as the breaking-out tools are usually within the contour which is defined by the free edges of the
10 surfaces.

Engagement of the breaking-out tools can also become more efficient when an edge opening is disposed in opposite relationship to the free end of the tools, the edge opening extending from the free edge of the support surface.

15 It has proven to be desirable to associate with the support surface, as a breaking-out tool, a pressure pin having a rounded free end or a fork member with one or more finger-like fork prongs, preferably of flat cross-section.

In particular small waste pieces also take part in the bending
20 movement of the breaking-out tool, in such a way that they assume a perpendicular position. When dealing with smooth cardboard surfaces, that results in slipping movement of the pressure pins on the surface of the cardboard and thus results in the waste portions being unsatisfactorily broken away. Therefore, for the sake of better engagement, the free end
25 of the pressure pin or the fork prongs is in the form of a rough surface. That rough surface can be formed by a coating which for example is formed with oxides, carbides, corundum or the like and is possibly applied by means of thermal spraying. Another embodiment according to the invention provides a rough surface with irregularities such as teeth or
30 steps in the surface of the pressure pin or the fork prong or prongs. The

irregularities can be produced by a mechanical, chemical or electrical treatment.

By virtue of the rough surface described - for which protection is claimed separately - the arrangement affords the desired firm engagement and the piece which is to be broken away is effectively prevented from sliding away. For that purpose, it has been found sufficient for the axial height of the rough surface to correspond at most to the diameter of the pressure pin or the width of the fork prong, preferably making it less than 5 mm.

Each fork member is to project from a plate-shaped male die and in accordance with the invention it is connected thereto by a portion of the fork member which has clamping noses and which can also have abutments which are guided against the underneath surface of the male die.

Other insert portions for the female die are shaped support portions which are arranged in the opening of the female die at the edge thereof and which are fitted to plug-in profile members and which are disposed in mutually opposite relationship and which are provided with mutually directed radial support lips of elastic material. Preferably that shaped support portion is an angle portion of which one limb is the support lip, while the other limb formed thereon is formed by a hollow profile member; the latter preferably corresponds to a cylindrical cup and is pressed on to a plug-in profile member by a simple assembly procedure in the breaking-out direction.

The scope of the invention also embraces clip-like tools which are fixed at the opening in the female die and which each include a respective frame portion from which resilient support tongues project inwardly or on which are arranged inwardly disposed support plates which can be guided about a pivot axis; that arrangement therefore affords simple additional tools in the form of spring clips or mechanically moved clips which would even permit standardisation of the tools.

Further advantages, features and details of the invention will be apparent from the description hereinafter of preferred embodiments and with reference to the drawing in which:

Figure 1 is a plan view of a support tool for a waste portion for the removal thereof from cardboard sheets in the corrugated cardboard and folding box industry,

Figure 2 is a side view of Figure 1,

Figure 3 is a side view corresponding to Figure 2 of another embodiment,

Figures 4 through 7 are diagrammatically illustrated successive method steps with a breaking-out board which is shown in section and which includes a support tool as shown in Figures 1 and 3 and with which a breaking-out tool is associated,

Figure 8 is a view on an enlarged scale approximately corresponding to Figure 6, with a support tool which is modified in relation to Figure 6, and another breaking-out tool,

Figure 9 is a plan view of a part of a further breaking-out board with support tool and breaking-out tool as shown in Figure 8,

Figure 10 is a view corresponding to Figure 9 of a further embodiment,

Figure 11 is a perspective view of a further support tool with breaking-out tool and the indicated end positions of a movable support plate,

Figure 12 is a view corresponding to Figure 11 of an arrangement with a breaking-out tool,

Figure 13 is a diagrammatic view in section relating to Figures 11 and 12,

Figures 14 and 15 respectively show a support tool in plan and a breaking-out tool illustrated in section,

Figure 16 is a front view in section of the arrangement shown in Figure 9,

Figure 17 shows the mounting arrangement for the breaking-out tool of Figure 16 taken along line XVII-XVII therein,

Figure 18 is a front view of a plate-like breaking-out tool in two embodiments,

5 Figure 19 shows two side views in relation to Figure 18,

Figure 20 is a view in section on an enlarged scale through a further embodiment of the breaking-out tool of Figure 18,

Figure 21 is a view corresponding to Figure 18 of a further breaking-out tool,

10 Figure 22 is a side view relating to Figure 21,

Figure 23 is a front view of another breaking-out tool,

Figures 24 through 26 show side views of three other embodiments of the breaking-out tool,

15 Figures 27 and 28 show the breaking-out tool of Figure 24 in two stages of a breaking-out operation,

Figures 29 and 30 respectively show a perspective view of a unit comprising a support tool and a breaking-out tool,

Figure 31 shows a perspective view of another breaking-out tool,

20 Figure 32 shows a perspective view of another embodiment of a support tool,

Figures 33 and 34 show two views corresponding to Figures 4 and 5 respectively of a working operation with support tools as shown in Figure 32,

25 Figures 35 through 38 show plan views of special tools having a spring action,

Figures 39 and 40 show plan views of special tools having a mechanical action,

Figures 41, 43 and 46 show sectional views of breaking-out boards with respectively inserted support tools,

30 Figures 42, 44 and 45 show plan views of the structures shown in Figures 41, 43 and 46,

Figure 47 is a front view of the support tool of Figures 43 and 44, and

Figure 48 is a perspective view of the support tool of Figures 46 and 47.

5 Cardboard sheets 10 which are used in the folding box industry have stamped blanks for folding boxes or the like, with waste portions 12 being produced in or on the blanks. Downstream of a stamping station which is not shown in the drawing for reasons of enhanced clarity thereof, the stamped cardboard sheet 10 passes on to a breaking-out board or a
10 female die 14 of a thickness b for example of 12 mm, on which the sheet 10 is freed of its waste portions 12; the waste portions 12 are disposed over openings 16 which are of a configuration designed in dependence on the contour of the waste portions 12 and at which, in the cross-sectional view in Figures 4 through 7, an upper frame portion 17 with a vertical wall is followed by a downwardly opening conical portion 18.

15 Fixed in the opening 16 is a support tool 20 for the waste portion 12, which as shown in Figures 1 and 2 is a kind of angle portion having two limbs 22 and 24 of flexible plastic material with a high level of endurance in relation to fluctuating loadings thereon. Projecting from the
20 limb 22 which extends vertically in the position of installation is a coupling rib 27 which has flanks 26 of an undercut configuration and which is inserted into a vertical groove 28 of dovetail-shaped cross-section in the female die 14. As Figure 9 clearly shows the vertical groove 28 extends from a wall surface 15 defining the opening 16.

25 The resilient horizontal limb 24 of the support tool 20, of a thickness a , has an inner opening 30 and at its free edge 25 an edge opening or recess 32; two prong-like cantilever portions 34 of the horizontal limb 24, which flank the edge opening 32, are curved in longitudinal section and each form a kind of bowl or cup.

30 In the embodiment shown in Figure 3, formed on the vertical limb 22 is a catch finger 38 for the waste portion 12. The catch finger 38 is

curved downwardly in its longitudinal section and narrows towards its free end 36.

The waste portion 12 which rests on the surface 25 of the horizontal limb 24 is subjected to a pressure from above by a breaking-out member or tool in the form of a pressure pin 40 with a roughened part-spherical pressure end which is similar to a fingertip, with the contact between the pressure end and the waste portion being in point form or - for example in Figures 8 and 12 - as a fork member 41, in substantially linear configuration; the flat fork prongs 42 of the fork member 41 are aligned with each other. Both the part-spherical pressure end of the pressure pin 40 and also the flat ends of the above-mentioned fork prongs 42 are provided with a coating 44, affording the roughness thereof, of an axial height h of between about 4 and 10 mm. The coating was produced for example by thermal spraying from aluminum oxide, corundum, carbide grains or the like.

The preferred height h is at most equal to the diameter d of the pressure pin 40 and the roughness depth is less than 0.5 mm. That coating can also be replaced by roughening of the surface of the pressure pin or the flat prong 41, which is effected chemically, electrically or - for example by means of sand blasting - mechanically.

In the downward movement of the breaking-out tool or tools 40, 41, the waste portion 12 is separated by pressure from the cardboard sheet 10 and carried away downwardly in the breaking-out direction x .

In the embodiment shown in Figure 9 the edge opening 32 is at its end of a part-circular contour and the horizontal limb 24 is flanked by side portions which respectively form the above-described catch fingers 38 and which - like also the horizontal limb 24 itself - are formed on the vertical limb 22.

Figure 10 indicates a connection pairing between the support tool 20_n and the female die 14, which is modified in relation to the embodiment shown in Figure 9; the female die 14 engages with a vertical bar 29 which

projects from the wall surface 15, into a vertical groove 31 in the support tool 20 or the vertical limb 22 thereof. The flank of the vertical groove 31 is identified by reference 26_a.

In the support tool 20_a shown in Figures 11 and 12, the support surface 25 for the waste portion 12 is provided by a support plate 46 which hangs separately between side walls 23; the support plate 46 rests with lateral trunnions which are not visible - pivot axis A - in finite mounting grooves 48 in the side walls 23 and can be moved from the horizontal position into the inclined position indicated at 46_a. In that position the support plate 46 is disposed in approximately parallel relationship with the inclined front ribs 50 of the side walls 23, the front ribs 50 also forming catch fingers.

Figure 13 is intended to show the manner of suspending the support plate 46 forming a kind of mechanical finger, as well as forwardly and downwardly inclined front surfaces 52 of the side walls 23, as deflector means for the waste portion 12.

The support plate 46_a in Figure 14, which is intended for long waste portions 12, shows two edge openings or chambers 32, with which there are associated flat prongs 42 of a fork member 41 which is otherwise not shown herein.

In Figure 15, strip-like cantilever portions 34_a of flexible material project from oppositely disposed wall surfaces 15 which define the opening 16. The cantilever portions 34_a form between them chamber spaces 33 of a width as indicated at n; the cantilever portions 34_a flank the pressure pins 40 which engage into the chamber spaces 33, or flat prongs 42 corresponding to the pressure pins.

Figures 16 and 17 show that the fork member 41 is firmly driven into a male die 51 of plywood of a thickness b₁ of for example 12 mm, as far as abutments 54 which are formed from the fork member 41 and which are directed transversely with respect to the prong axis B. The firm fit is produced by means of abutment plates 59 (Figures 21 through 23)

which are near the upper edge and which are parallel to the prong axis B, or by means of clamping noses 60 or gripping ridges which project at both sides from the surfaces 58 of the fork member 41.

5 The ridge-like clamping nose 60 or the abutment 54 respectively can also be seen in the fork member 41_a shown in Figures 18 through 25. The free ends of the fork prongs or flat prongs 42 - the free ends being defined by straight or curved end edges 43 and 43_a respectively - have in this case mechanically produced roughness in the form of teeth 61 which are inclined at about 30° in Figures 18 and 19 and which are shaped near
10 the edge at one or both sides, teeth 61_a which project at about 90° in Figures 21 and 22, hooks 61_b (Figure 20) or shoulders 61_c which are formed on fork prongs 42_a.

In addition Figure 23 shows a breaking-out tool 41_b with only one flat prong 42_b which is delimited downwardly by the above-mentioned end
15 edge 43_a which is curved in cross-section.

In that respect, Figures 27 and 28 clearly show how a small waste portion 12 is engaged by the free end of the flat prongs 42_a and laid into the shoulder 61_c, for perpendicular positioning thereof. Reliable downward guidance of the waste portion 12 is ensured by virtue of the fact that it is
20 pressed in force-locking engagement against the breaking-out tool or fork member 41_a by the cantilever portion 34 of the support tool 20. Because the waste portion 12 is caused to bear against the breaking-out tool 41_a in force-locking engagement therewith in that way, the shoulders 61_c produce their effect. In the breaking-out process the breaking-out tool 41_a
25 presses the waste portion 12 against the support tool 20, clamps it in place and guides it positively downwardly. In that procedure the waste portion is disposed approximately perpendicularly. Upon further downward movement of the breaking-out tool, the waste portion 12 is pushed downwardly by the tooth 61, 61_a - or the hook 61_b or the shoulder 61_c.
30 The support tool 20 or the cantilever portion 34 thereof moves rapidly back into its initial position.

The described system affords advantages not only in relation to internal waste portions 12, but also in relation to so-called edge waste; the procedure for breaking away edge waste is effected only with the above-described combination of the breaking-out tool 41_a and the support tool 20; wooden die or support members are unnecessary. The risk which arises due to wooden die or support members which are necessarily disposed close to the breaking-out female die 14 no longer arises. A spacing of 4 mm between the breaking-out tool 41_a and the outside contour of the breaking-out female die 14 affords sufficient tolerance and security. A movement in the severing operation, which corresponds to the pitching action, carries the edge waste positively away from the breaking-out female die 14. As in the case of internal waste, in this case also the edge waste is disposed perpendicularly and is reliably guided downwardly by the thrust teeth 61, 61_a, 61_b, 61_c.

Figure 29 shows an illustrative perspective view of a female die 14 which is made from plywood, with an angle portion 20 which serves as a support tool being releasably secured to the opening 16 thereof; disposed above the angle portion 20 is a fork member 41_a with shoulders 61_c which are formed in its flat prongs 42_a.

The fork member 41_a in Figure 30 shows the teeth 61 which project inclinedly from the flat prongs 42 into the intermediate spaces between the prongs, and a region of a coating 44 on the finger or end portions 45 of the flat prongs, which are shaped downwardly as pointed tips.

The breaking-out tool 41_b in Figure 31 - corresponding to that shown in Figure 23 - is provided with a flat prong 42_a which is here disposed laterally and which has a shoulder 61_c at its end.

Referring to Figures 33 and 34, in an opening 16_a of the same cross-section throughout, the female die 14_a shown therein receives on both sides a shaped support portion 62 which is clearly illustrated in Figure 32 and which comprises a cylindrical inversion-action neck 63 and a radial

support lip 64 which in turn has an edge opening 32. The inversion-action neck 63 is connected to a plug-in profile member 65.

The waste portion 12 which lies on the mutually facing support lips 64 is urged in the breaking-out direction against the support lips 64 by pin-like breaking-out tools 40 which are provided above the support lips 64. In that case, the support lips 64 are elastically deformed and, when relieved of load, move quickly back into the initial position. In this case also, the breaking-out tools 40 are arranged in the region of the edge openings 32.

The drawing shows in plan hereinafter some diagrammatic views of special tools, more specifically Figures 35 and 36 showing spring clips 66, 66_a for waste portions 12_a and 12_b respectively of round and half-round contour, while in addition Figures 37 and 38 show spring clips 70 and 68 for waste 12_c of an extended so-called Euro-hole or for cigarette waste 12_d. Figures 39 and 40 show mechanical clips 72 and 72_a respectively for round waste portions 12_a and for rectangular waste portions 12.

These special tools 66, 66_a, 68, 70, 72, 72_a - which are suitable as a basis for standardisation - each have a frame portion 76 from which project spring tongues 34_a which are directed inwardly in Figures 35 through 37. The rectangular frame portions 76 of the clips 72, 74 in Figures 39, 40 include support plates 46_b which are possibly of a resilient nature and which are limitedly rotatable about a respective pivot axis A and into whose edge opening or openings 32 projects a respective pressure profile member 78.

Figure 41 shows a support tool 20_e whose vertical limb 22 which is of rectangular cross-section is provided with a strip 80 which is parallel thereto at a spacing y, forming a channel; the two are connected by a transverse web portion 82 which is formed thereon at both sides.

The parallel strip 80 engages from below into a stamped-out opening 84, which is of a cross-section corresponding to the parallel strip 80, in the breaking-out board 14. The stamped-out opening 84 is

separated from the opening 16 of rectangular cross-section, by a board web portion 86 which is disposed in the above-mentioned channel. A vertical groove 28_a - also of rectangular cross-section - extends from the opening 16, with stepped flank surfaces 88. The vertical limb 22 of the support tool 20_f in Figures 43 through 45 is also carried in the back region 90 of a vertical groove 28_a. Plug-in strips 92 of L-shape in longitudinal section are formed at a spacing y, by virtue of the above-mentioned transverse web portions 82, on the flanks of the vertical limb 22. In the rest position shown in Figures 43 and 44, the strips 92 are fitted into corresponding flank holes 94 in the breaking-away board 14 - the latter are therefore in alignment with the back region 90 of the vertical groove 28_a.

A support arrangement 96 in the breaking-away board 14 in Figures 46 and 47 comprises an angular plastic body 21 which is provided for the vertical groove 28_b, the plastic body having a short vertical limb 97 which has a downwardly open plug-in passage 92 for a plug-in tongue 99, of rectangular cross-section, of the vertical limb 100 of an angle bracket 102. Its limb 101 which is horizontal in Figures 46 and 47 is fixed in force-locking engagement to the underneath surface 13 of the breaking-out board 14.

CLAIMS

1. Apparatus for removing broken-out pieces, in particular waste portions, from a sheet of material which contains blanks or the like flat portions and which rests on a female die or the like breaking-out surface in such a way that the broken-out portion extends over an opening in the breaking-out surface and is urged away through the opening under the pressure of at least one breaking-out tool, wherein associated with the breaking-out tool is a support means which is movable in the direction of movement of the breaking-out tool and which projects into the opening and which in the rest position engages in substantially parallel relationship under the waste portion or broken-out piece disposed in the sheet of material and which is adapted to be variable in its position upon the movement of the waste portion by the breaking-out tool and in particular is adapted to be transferred into an angle of inclination relative to the sheet of material in the downward movement of the waste portion, characterised in that the support means is formed by a support tool (20, 20_a, 20_b, 20_e, 20_f, 20_n; 21; 34_a; 62; 66, 66_a; 68; 70; 72, 72_a, 96) which is rigidly connected in positively locking relationship to the breaking-out surface or female die (14) in the edge region of the opening (16, 16_a) and is provided with a contact or support surface (24, 25, 34_b; 64) which can be inclined with respect to that connection pairing (27, 28, 29, 31; 63, 65).

2. Apparatus as set forth in claim 1 characterised in that the connection pairing comprises at least one undercut receiving groove (28) in the female die (14) at the edge of the opening (16) thereof on the one hand and a coupling bar or rib (27) which can fit thereinto on the other hand.

3. Apparatus as set forth in claim 1 characterised in that the connection pairing comprises at least one undercut receiving groove (31) in the support tool (20_n) on the one hand and a coupling bar (29), which can be fitted into the receiving groove, on the female die (14) at the edge of its opening (16) on the other hand.

4. Apparatus as set forth in claim 2 or claim 3 characterised in that the receiving groove (28, 31) and the coupling rib or bar (27, 29) extend in the breaking-out direction (x).

5. Apparatus as set forth in one of claims 2 through 4 characterised in that the cross-sections of the receiving groove (28, 31) and the coupling rib or bar (27, 29) are of a dovetail-shaped configuration.

6. Apparatus as set forth in one of claims 1 and 2 or 4, 5 characterised in that the support tool (20) is an angle portion with at least one coupling rib (27) which is formed out of its one limb (22) and with another flexible limb (24) which forms the support surface (25).

7. Apparatus as set forth in one of claims 1 and 3 or 4, 5 characterised in that the support tool (20_n) is an angle portion with at least one vertical groove (31) formed in a limb (22), and with another flexible limb (24) forming the support surface (25).

8. Apparatus as set forth in claim 1 characterised in that the connection pairing comprises at least one receiving groove (28_a, 28_b) in the female die (14) at the edge of the opening (16) thereof on the one hand and a portion (80, 92, 97), which can be fitted into the receiving groove, of a vertical limb (22) of the support tool (20_e, 20_f, 21) on the other hand.

9. Apparatus as set forth in claim 1 or claim 8 characterised in that the support tool (20_e, 20_f, 21) is an angle portion with at least one vertical limb (22, 97) and another flexible limb (24) providing the support surface (25).

10. Apparatus as set forth in one of claims 1 through 8 characterised in that the support tool or the angle portion (20, 20_e, 20_f, 20_n, 21) is formed from a limitedly flexible plastic material.

11. Apparatus as set forth in claim 8 or claim 9 characterised in that the flexible limb (24) forming the support surface (25) has an edge opening (32) which is delimited on both sides by cantilever portions (34), and at least one inner opening (30) at a spacing in relation to the edge opening (32).

12. Apparatus as set forth in one of claims 8 through 11 characterised in that formed on the vertical limb (22) is at least one pin-like plug-in element (80, 92) which extends or extend at a spacing (y) relative to the vertical limb and which is respectively adapted to be inserted into an opening (84, 94) provided in the female die (14) at a spacing (y) relative to the receiving groove (28_a).

13. Apparatus as set forth in claim 12 characterised in that the plug-in element (80, 92) and the opening (84) are of rectangular cross-section and/or that the plug-in element (80) projects from a transverse web portion (82) at a spacing (y) relative to the rear surface of the vertical limb (22).

14. Apparatus as set forth in claim 12 or claim 13 characterised in that the plug-in element (22) projects up from a transverse web portion (82) at a spacing (y) relative to the flank surface of the vertical limb (22).

15. Apparatus as set forth in one of claims 1 through 14 characterised in that the flank surfaces (88) of the vertical groove (28_a, 28_b) are stepped and the vertical limb (22) is supported in the rear region (90) of the vertical groove, which rear region is of narrower cross-section.

16. Apparatus as set forth in one of claims 8 through 11 characterised in that the vertical limb (97) is connected with a coupling pairing (98/102) to a limb (100) of an angle bracket (102), which extends in the vertical groove (28_b), while the other limb (101) of the angle bracket is connected to the female die (14).

17. Apparatus as set forth in one of claims 1 through 7 characterised in that arranged downstream, in the breaking-out direction (x), of the limb (24) forming the support surface (25) is at least one catch finger (38), in particular a pair of catch fingers.

18. Apparatus as set forth in claim 7 or claim 17 characterised in that the limb (24) forming the support surface (25) is flanked by side portions which are formed on the other limb (22) and form the catch fingers (38).

19. Apparatus as set forth in claim 17 or claim 18 characterised in that the catch finger (38) is enlarged in longitudinal section from its free end (36) towards the limb (22) formed thereon.

20. Apparatus as set forth in one of claims 1 through 19 characterised in that the support tool (20_a) has a partial frame which is substantially U-shaped in cross-section and which comprises a back portion including the coupling rib or ribs (27), with two parallel side walls

(23), wherein a support plate (46, 46_a) is arranged pivotably about an axis (A) between the side walls.

21. Apparatus as set forth in one of claims 1 through 20 characterised in that the breaking-out tool or tools (40; 41, 42) extends or extend between surfaces (34, 34_a) of the support means (20, 20_a, 20_b, 20_n), said surfaces being movable in the breaking-out direction (x).

22. Apparatus as set forth in one of claims 1 through 21 characterised in that the portion (24; 46, 46_a; 64) including the support surface (25) is provided at its free edge (35) with at least one edge opening (32).

23. Apparatus as set forth in claim 21 or claim 22 characterised in that the edge opening or openings is or are disposed in opposite relationship to the free end or ends of the breaking-out tool (40, 41).

24. Apparatus as set forth in at least one of claims 1 through 23 characterised in that associated with the support surface (25) as a breaking-out tool is a pressure pin (40) with a rounded free end or a fork member (41, 41_a, 41_b) with one or more finger-like fork prongs (42, 42_a, 42_b) of preferably flat cross-section.

25. Apparatus as set forth in claim 24 characterised in that the free end of the fork prongs (42, 42_a, 42_b) is formed by a part-circular curve (43_a in Figures 18, 23) formed therein or a tip (Figures 30, 31) formed out thereon.

26. Apparatus as set forth in claim 24 or claim 25 characterised in that the free end of the pressure pin (40) or the fork prong (42, 42_a, 42_b) is in the form of a rough surface.

27. Apparatus as set forth in claim 26 characterised in that the rough surface is formed by a coating (44), in particular a coating with oxides, carbides, corundum or the like.

28. Apparatus as set forth in claim 26 characterised in that the coating (44) is applied by means of thermal spraying.

29. Apparatus as set forth in claim 26 characterised in that the rough surface is formed by a coating of plastic material or rubber.

30. Apparatus as set forth in claim 26 characterised in that the rough surface is formed by irregularities provided in the surface of the pressure pin (40) or the fork prongs (42, 42_a, 42_b).

31. Apparatus as set forth in claim 26 or claim 30 characterised in that the surface of the pressure pin or the fork prongs (42) is roughened mechanically, chemically or electrically.

32. Apparatus as set forth in claim 30 or claim 31 characterised in that the irregularities on the pressure pin (40) or the fork prongs (42, 42_a, 42_b) are formed by teeth (61, 61_a) formed out of same, hooks (61_b) or at least one shoulder (61_c).

33. Apparatus as set forth in one of claims 26 through 32 characterised in that the axial height (h) of the rough surface (44) corresponds at most to the diameter (d) of the pressure pin (40) or the width of the fork prong (42).

34. Apparatus as set forth in one of claims 24 through 33 characterised in that the fork member (41) projects from a plate-shaped

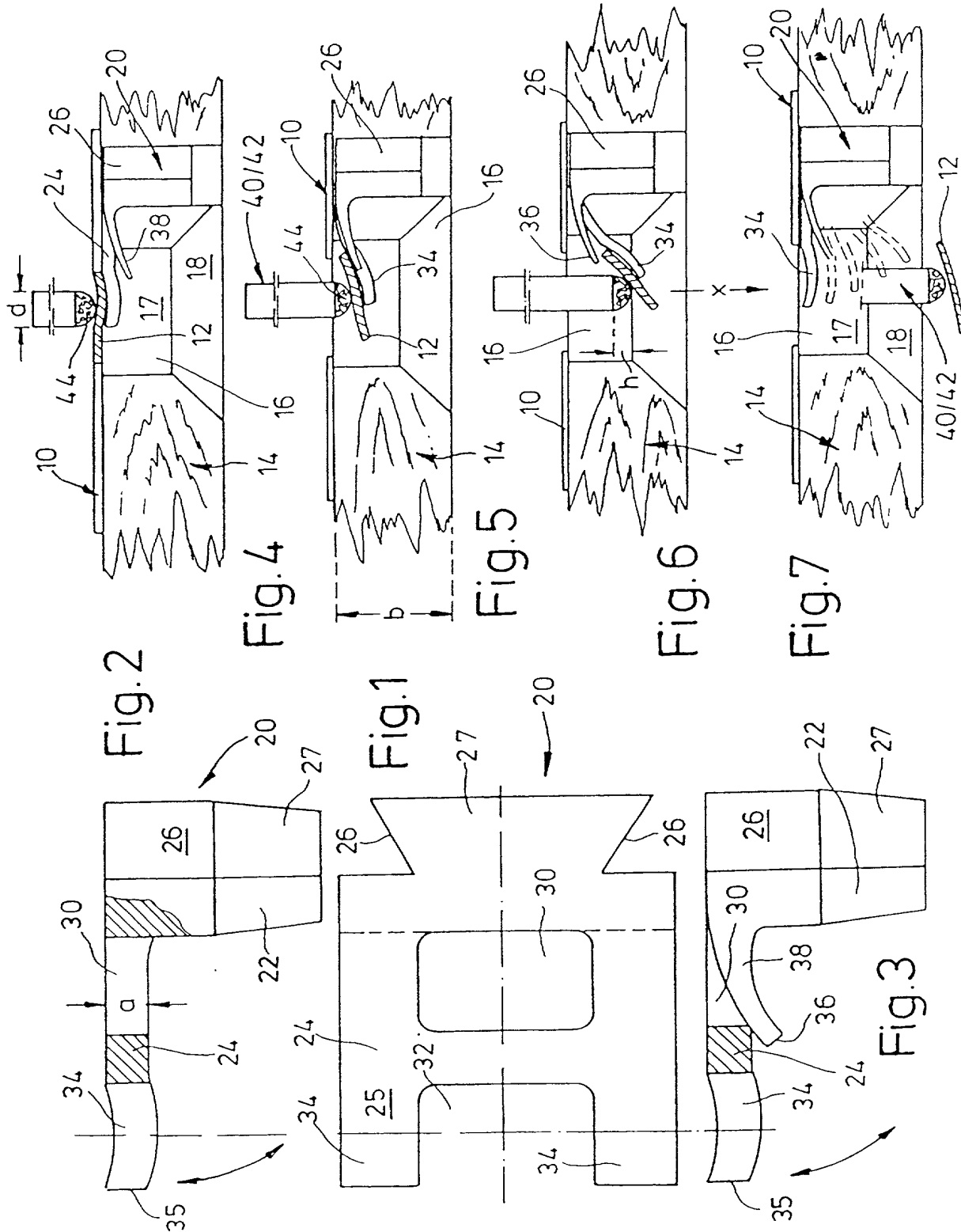
male die (56), wherein possibly the portion of the fork member (41), which is connected to the male die (56), has clamping noses (60) and/or abutments (54) (Figure 14).

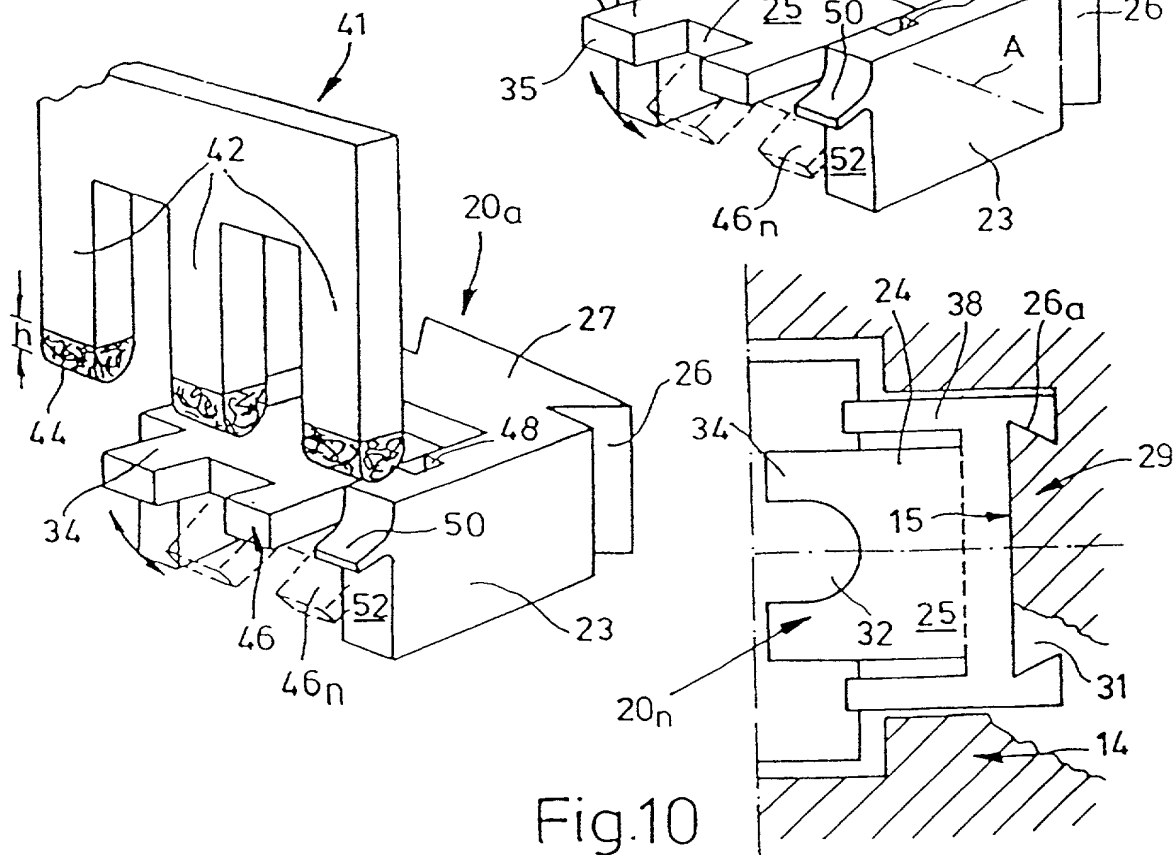
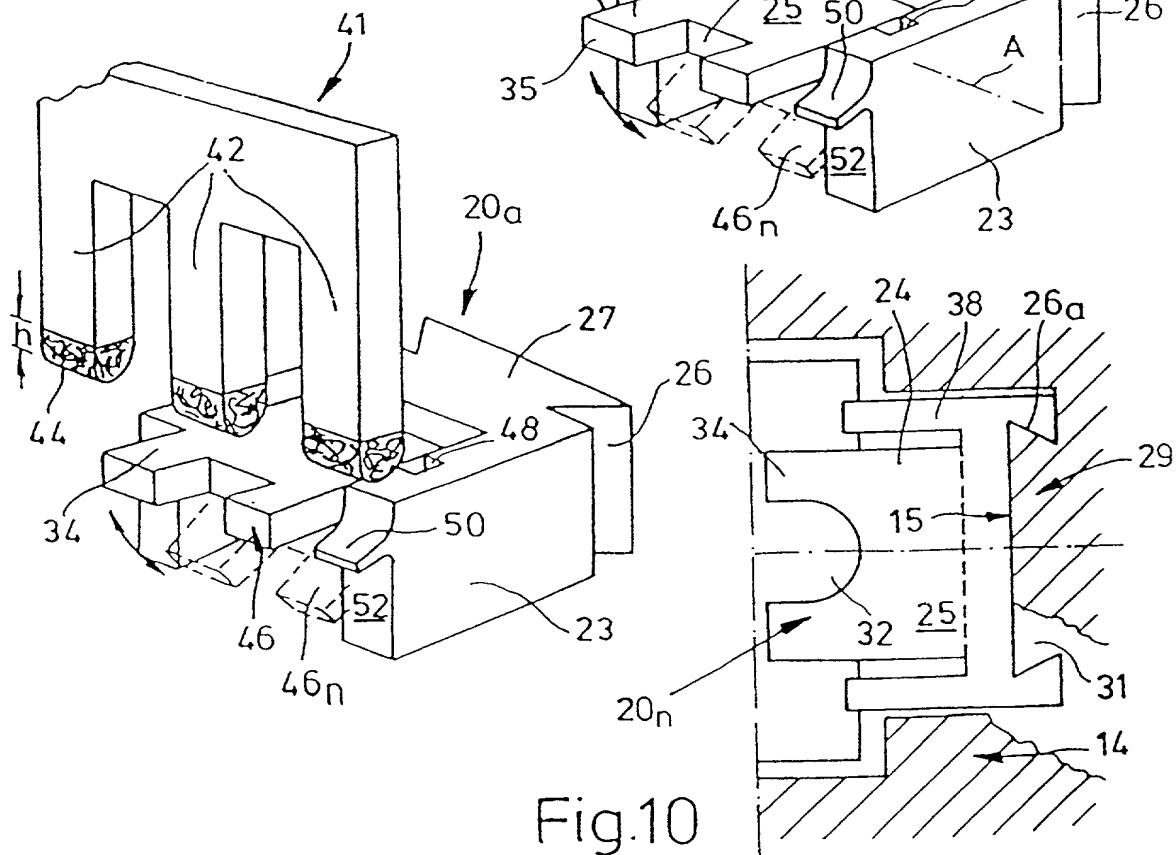
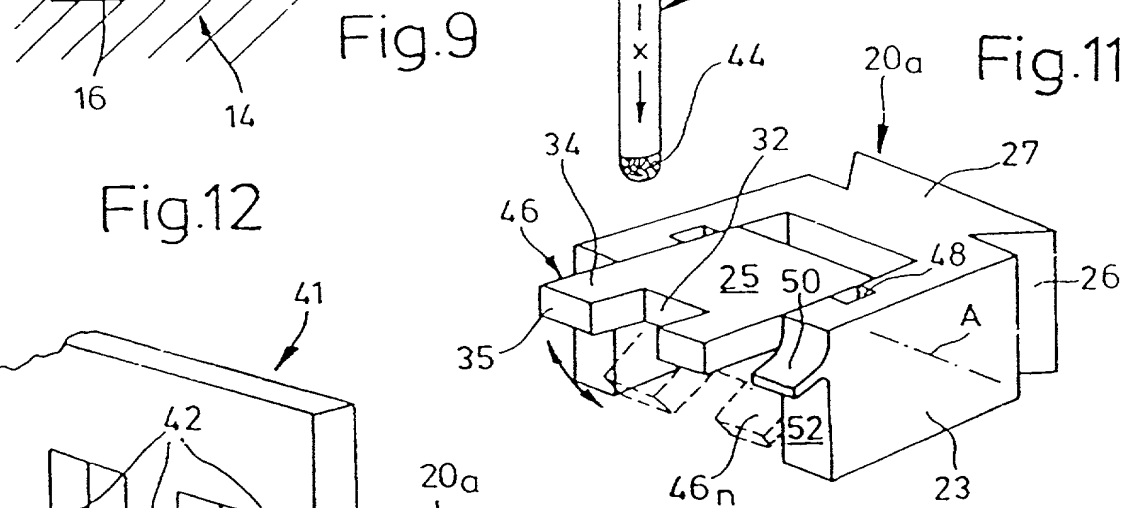
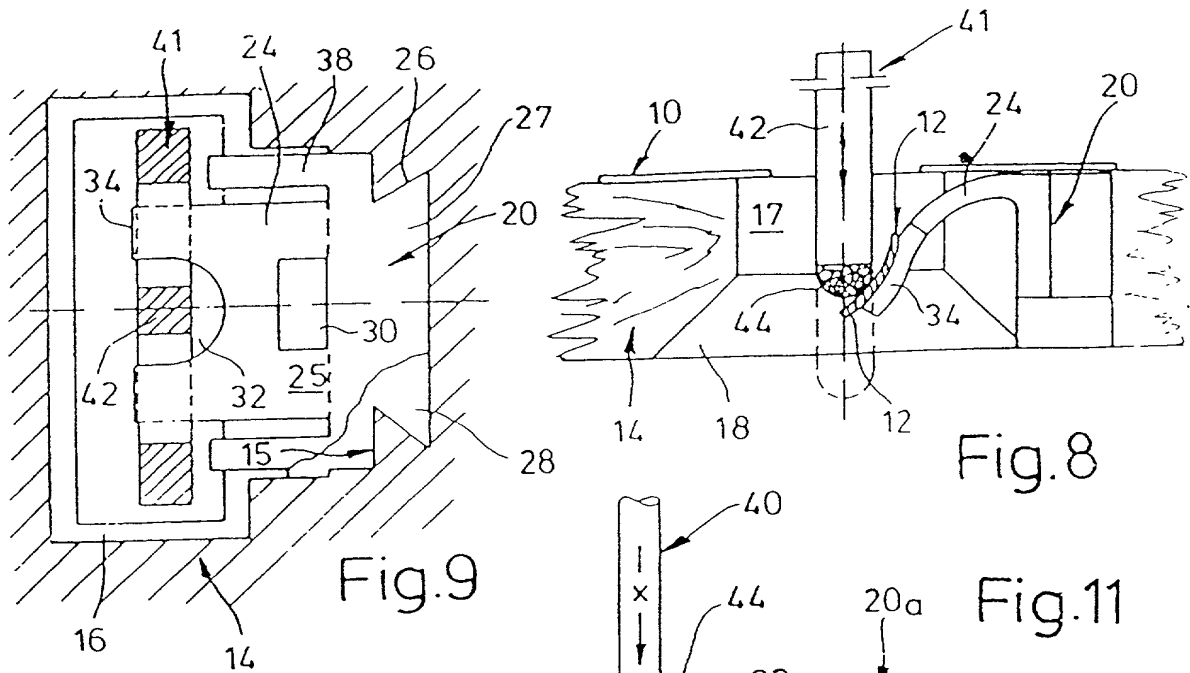
35. Apparatus as set forth in one of claims 1 through 34 characterised in that shaped support portions (62) which are arranged in the opening (16_a) at the edge thereof and which are fitted on to plug-in profile members (65) are disposed in mutually opposite relationship, the support portions (62) being provided with radial support lips (64) of elastic material which are directed towards each other.

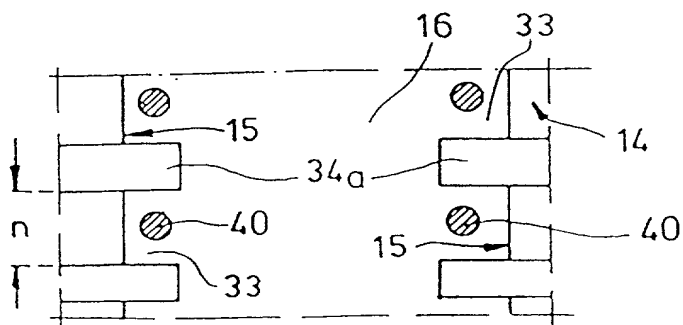
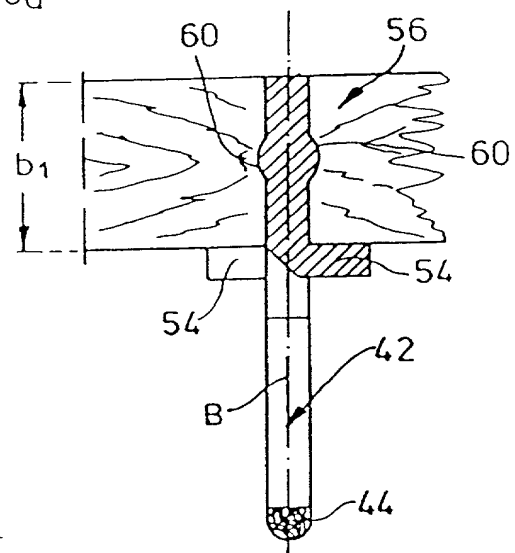
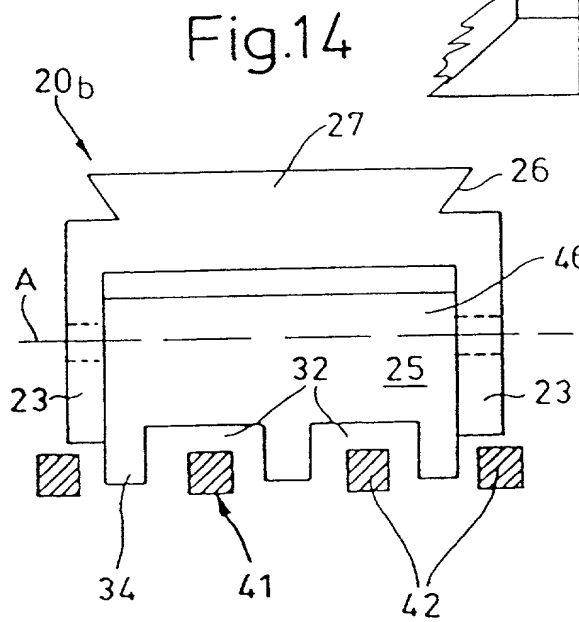
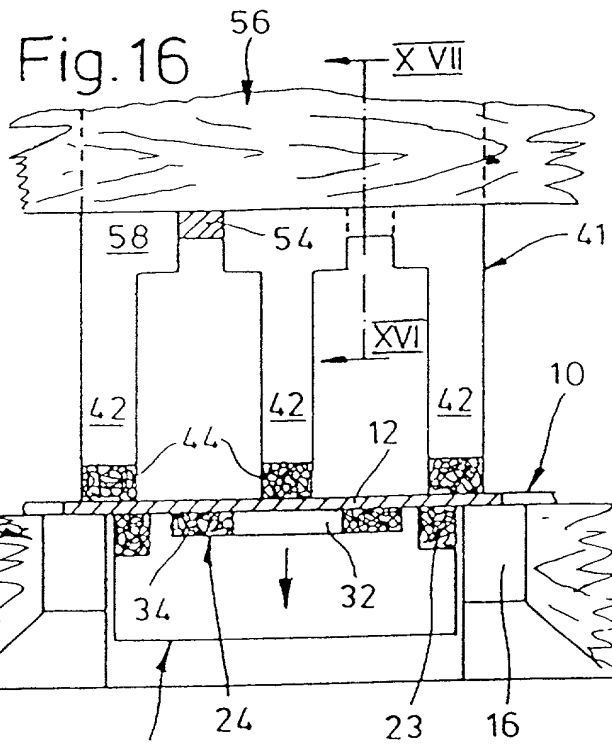
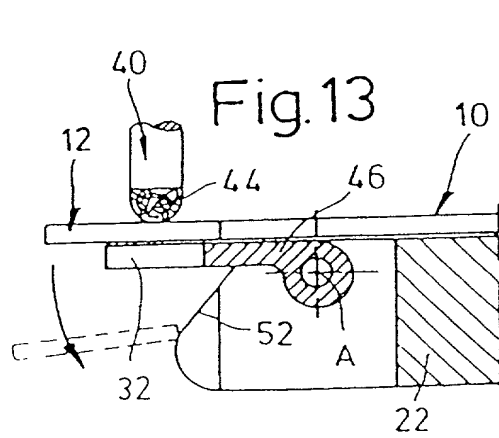
36. Apparatus as set forth in claim 35 characterised by an angle portion as a shaped support portion (62), of which one limb is the support lip (64), wherein the other limb formed thereon is formed by a hollow profile portion (63), wherein possibly the shape of the hollow profile portion (63) corresponds to that of a cylindrical cup.

37. Apparatus as set forth in one of claims 1 through 36 characterised by a clip-like tool (68 through 74) which is fixed to the opening (16, 16_a) and which respectively includes a frame portion (76) from which resilient support tongues (34_b) project inwardly or on which at least one inwardly disposed support plate (46_b) is arranged movably about a pivot axis (A).

38. Apparatus as set forth in claim 37 characterised by a frame portion (76) which is at least partially curved in plan view or by a substantially rectangular frame portion (76).







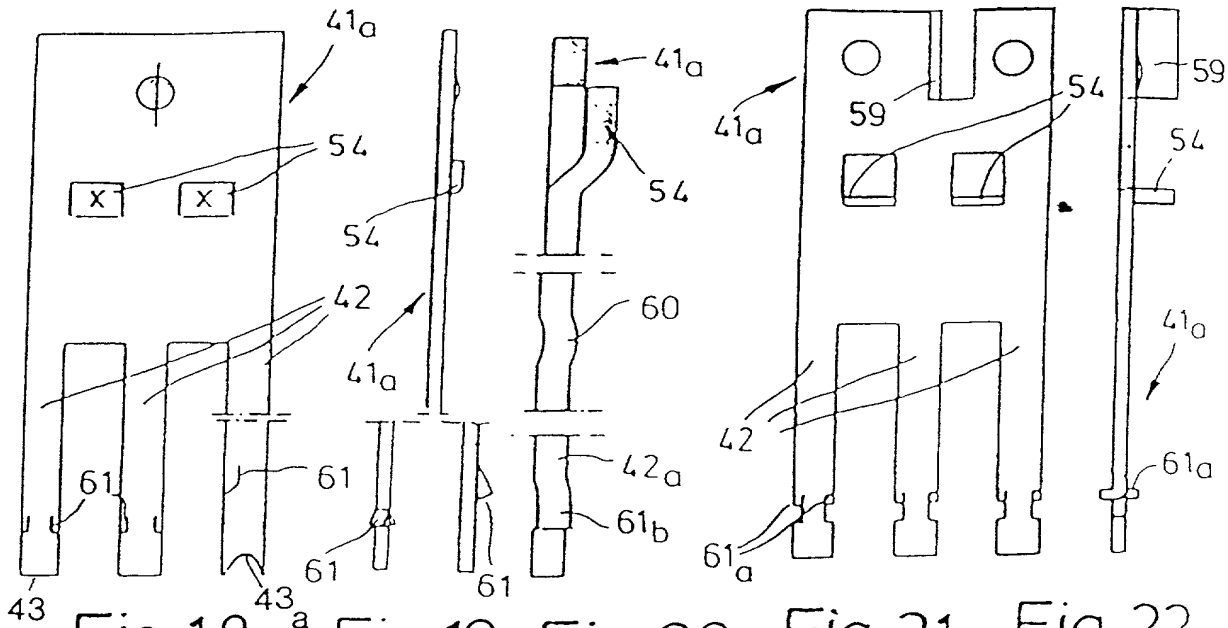


Fig. 18

Fig. 19

Fig. 20

Fig. 21

Fig. 22

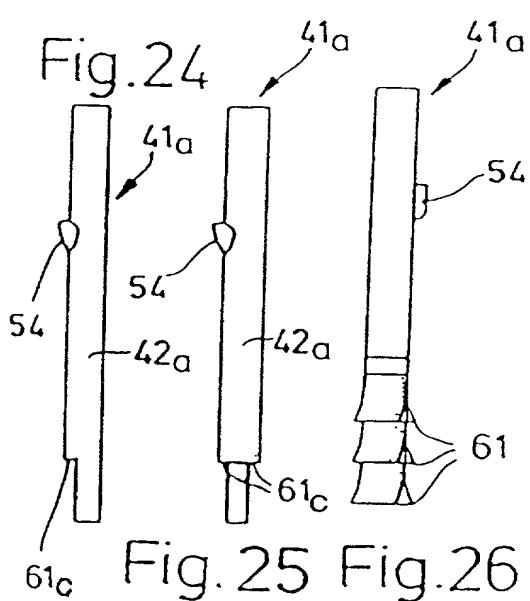


Fig. 24

Fig. 25

Fig. 26

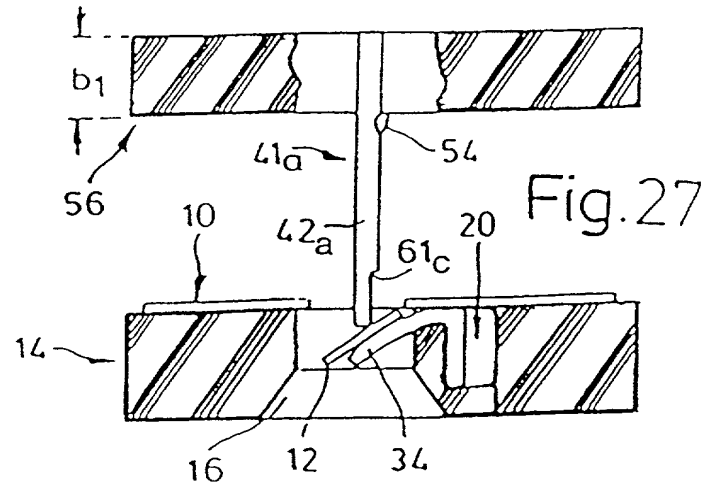


Fig. 27

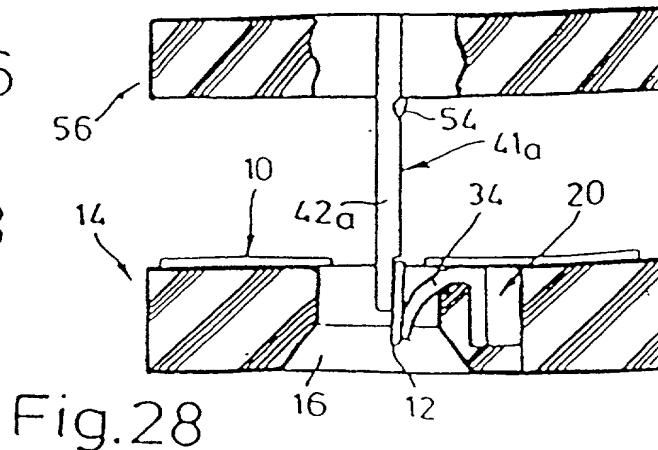


Fig. 28

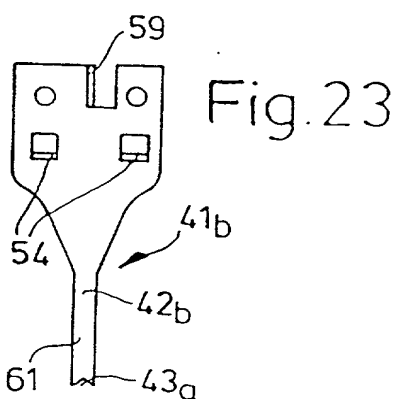


Fig. 23

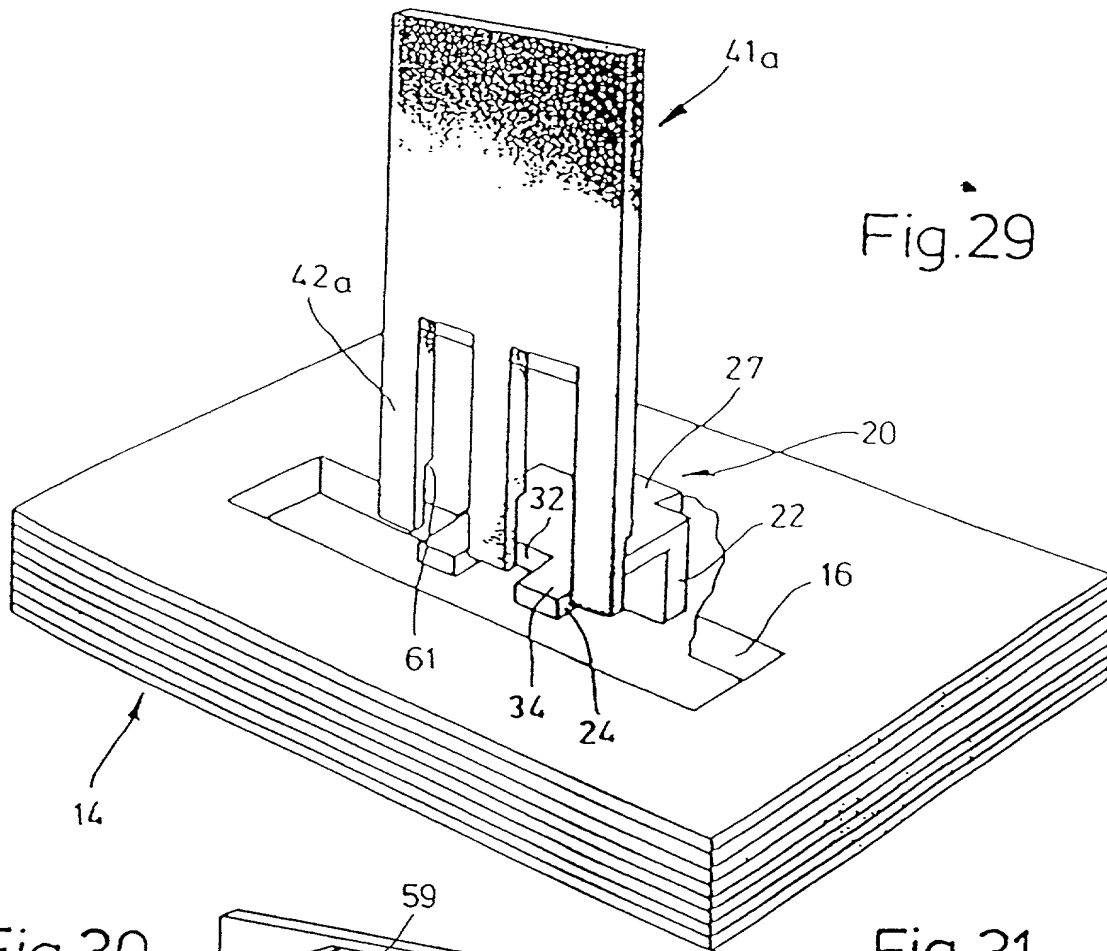


Fig. 29

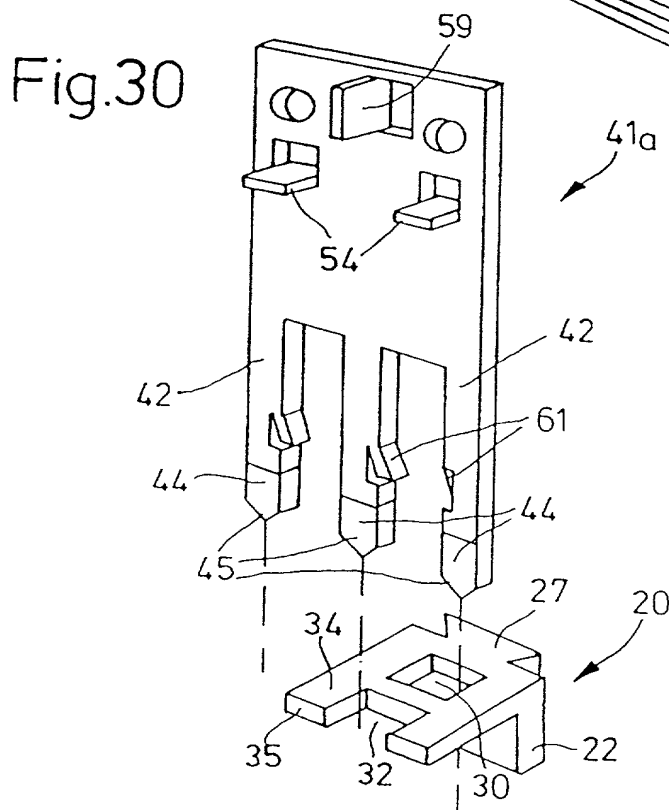
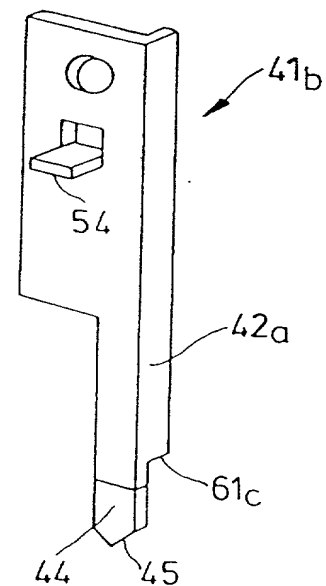


Fig. 30

Fig. 31



6/7

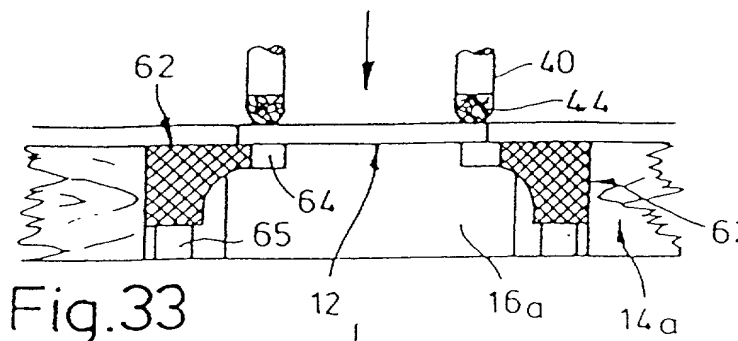


Fig. 33

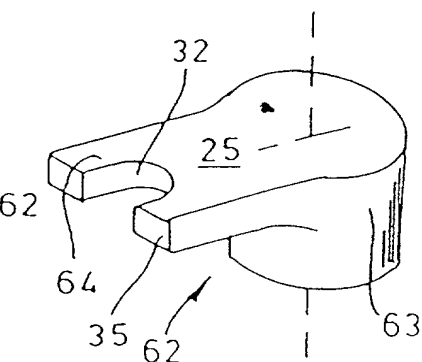
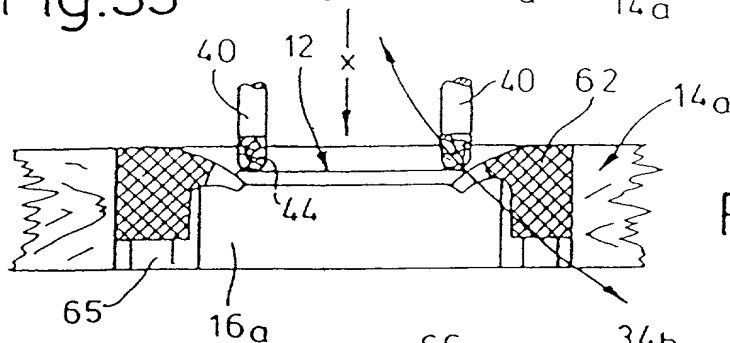


Fig. 32

Fig. 34

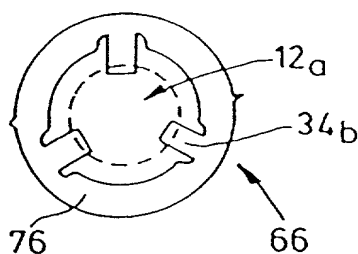


Fig. 35

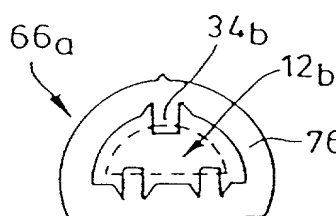


Fig. 36

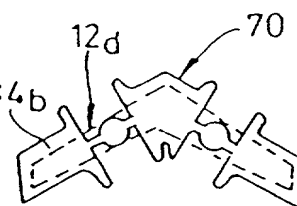


Fig. 37

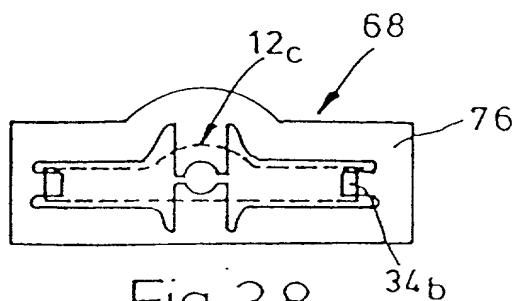


Fig. 38

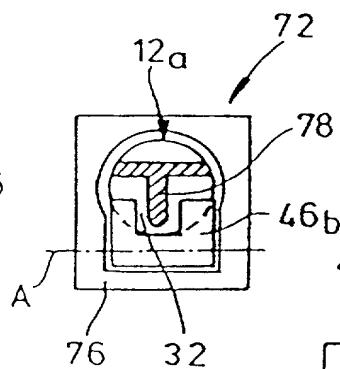
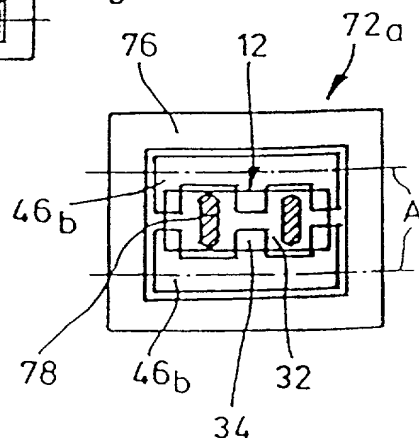


Fig. 39

Fig. 40



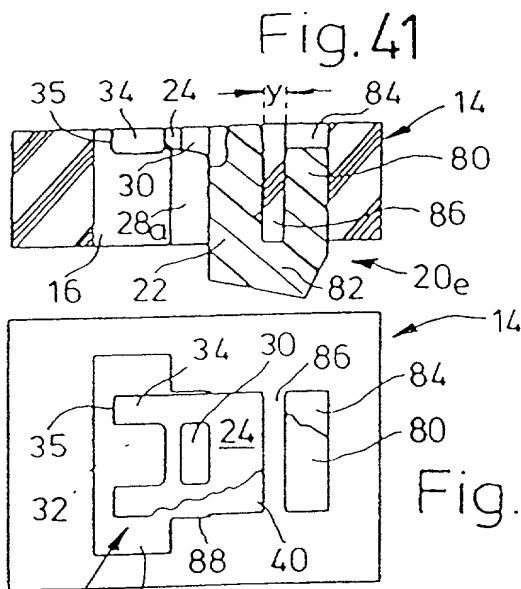


Fig. 43

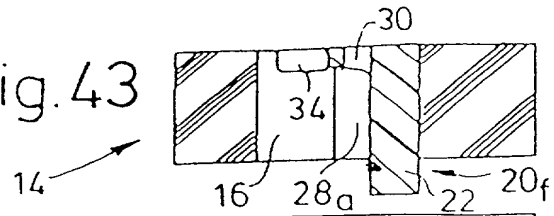


Fig. 44

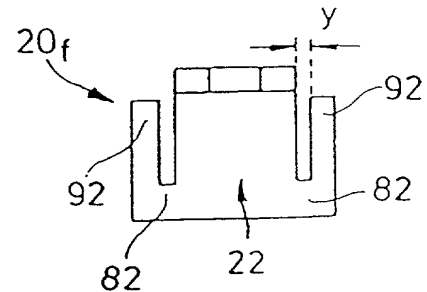
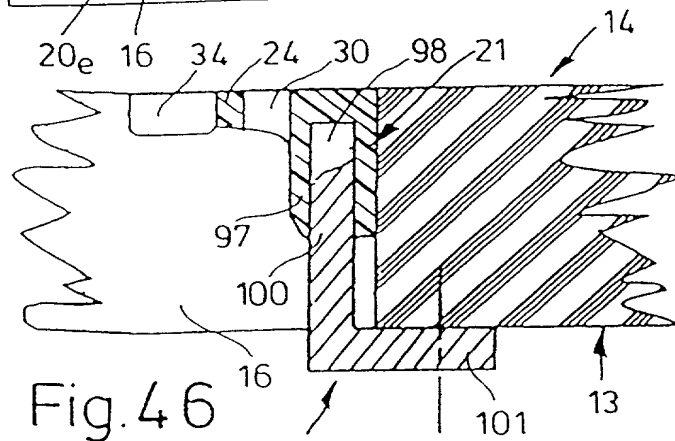
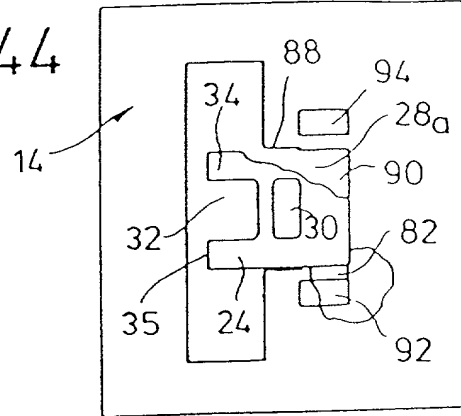


Fig. 4 6

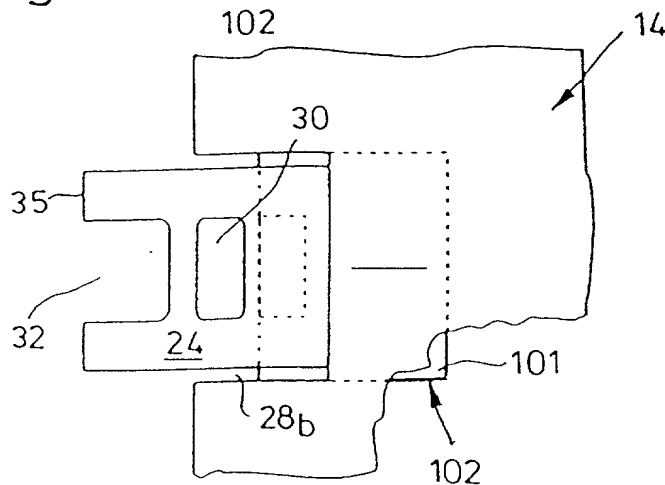
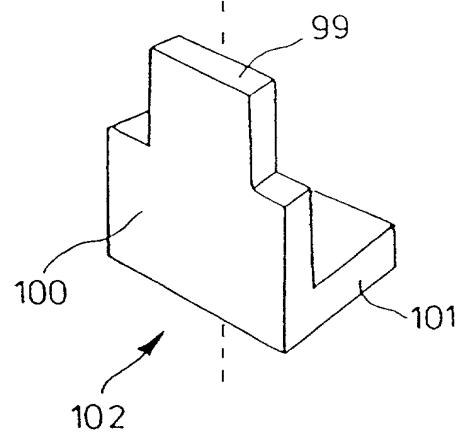


Fig.45

Fig. 48



- V132USp -
DECLARATION AND POWER OF ATTORNEY

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as
stated below next to my name,

VOSSEN, Franz
Steisslinger Strasse 46, 78333 Stockach,
Germany

I believe I am the original, first and sole inventor (if only
one name is listed below) or an original, first and joint inventor
(if plural names are listed below) of the subject matter which is
claimed and for which a patent is sought on the invention entitled:

DEVICE FOR REMOVING BREAK-OFF COMPONENTS FROM A SHEET OF MATERIAL OR
EQUIVALENT

Case No. 00-601, the specification of which

(check one)

is attached hereto.

xx was filed on April 1, 1999 as
PCT Application Serial No. PCT/EP99/02266
and was amended on _____
(if applicable)

I hereby state that I have reviewed and understand the
contents of the above identified specification, including the
claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is
material to the examination of this application in accordance with
Title 37, Code of Federal Regulations, §1.56(a) and understand that
information is material where there is substantial likelihood that
a reasonable examiner would consider it important in deciding
whether to allow the application to issue as a patent.

I do not know and do not believe this invention was ever known
or used in the United States of America before my or our invention
thereof, or patented or described in any printed publication in any
country before my or our invention thereof or more than one year
prior to this application, that the same was not in public use or
on sale in the United States of America more than one year prior to
this application, that the invention has not been patented or made
the subject of an inventor's certificate issued before the date of
this application in any country foreign to the United States of
America on an application filed by me or my legal representatives
or assigns more than twelve months prior to this application, and
that no application for patent or inventor's certificate on this
invention has been filed in any country foreign to the United
States of America prior to this application by me or my legal
representatives or assigns, except as identified below:

I hereby claim foreign priority benefits under Title 35,
United States Code, §119 of any foreign application(s) for patent
or inventor's certificate listed below
Prior Foreign Application(s)

Number	Country	Date
<u>198 14 736.8</u>	<u>Germany</u>	<u>02.04.98</u>
<u>198 20 557.0</u>	<u>Germany</u>	<u>08.05.98</u>
<u>198 37 316.3</u>	<u>Germany</u>	<u>18.08.98</u>
<u>298 15 042.5</u>	<u>Germany</u>	<u>21.08.98</u>
_____	_____	_____
_____	_____	_____

and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the above listed application on which priority is claimed:

Prior Foreign Application(s)

Number	Country	Date
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____

If no priority is claimed, I have identified all foreign patent applications filed prior to this application:

Prior Foreign Application(s)

Number	Country	Date
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____

And I hereby appoint Robert H. Bachman (19,374), Gregory P. LaPointe (28,395), Richard S. Strickler (18,228), and Barry L. Kelmachter (29,999), all members of the firm of Bachman & LaPointe, P.C., A Professional Corporation.

Telephone: 203-777-6628

my attorneys with full power of substitution and revocation, to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith and direct that all correspondence be forwarded to:

Bachman & LaPointe, P.C.
Suite 1201
900 Chapel Street
New Haven, CT 06510-2802

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Full name of sole or first inventor VOSEN Franz

Inventor's signature [Signature] Date 20.09.2000

Residence Germany

Citizenship German

Post Office Address Steisslinger Strasse 46
78333 Stockach, Germany

DEX